



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-588-011
Job Sheet 185553



Part No: D350-588-011

Job Qty: 5 ea

Part Name: Aft Door Fwd Hinge Modification



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9690 REV A, DSI9760-011 REV A, D350-588 REV D IPP Rev:M 04.08.31 Added D2690-17 KJ/JLM
IPP REV:G 14.04.28 AS PER DSI9690 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 09 2018
110	Packaging	5 pcs	11/16/18	11/16/18	0.00	0.00	Packaging1-3		NOV 14 2018
120	QC	5 pcs	11/16/18	11/16/18	0.00	0.00	QC4		NOV 15 2018
130	Packaging	5 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1		NOV 15 2018
135	DC	5 pcs	11/16/18	11/16/18	0.00	0.00	DC		NOV 15 2018
140	QC21-FG	5 Ea	11/16/18	11/16/18	0.00	0.00	QC21		NOV 15 2018

Part Op
Descriptions: 135 - Photocopy bluefile and create labels per PPP D350-588-011 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN526C1032R7	Screw	10 Ea (2 ea)	90-Start up Operation	FM1254034
AN526C832R8	Screw	40 Ea (8 ea)	90-Start up Operation	5115600
AN526C832R9	Screw	40 Ea (8 ea)	90-Start up Operation	5113841
D2143	Hinge Bracket	5 Ea (1 ea)	90-Start up Operation	5114710
D2144	Hinge Doubler	5 Ea (1 ea)	90-Start up Operation	5061022
D2150	Packer Doubler, Hinge	10 Ea (2 ea)	90-Start up Operation	5156276
D2151	Packer Doubler	10 Ea (2 ea)	90-Start up Operation	5118095
D2153	Door Prop	5 Ea (1 ea)	90-Start up Operation	5125579x4
D2154	Bracket, Stud	5 Ea (1 ea)	90-Start up Operation	5152222x4
D2237	Striker Plate	10 Ea (2 ea)	90-Start up Operation	5071070x4
D2461	Neoprene 'D' Seal (\$Per Foot)	36.2500 ft (7.25 ea)	90-Start up Operation	5126448
D2463	1/2" Seal (\$ Per Foot)	36.2500 ft (7.25 ea)	90-Start up Operation	5112744x2
D2583	Latch Bracket	10 Ea (2 ea)	90-Start up Operation	5049917x8
D2585	Latch Clamp	10 Ea (2 ea)	90-Start up Operation	5114502
D2586	Door Latch	10 Ea (2 ea)	90-Start up Operation	5116573
D2587	Door Plug	5 Ea (1 ea)	90-Start up Operation	5038352
D2589	Keys, Key Chain	5 Ea (1 ea)	90-Start up Operation	7130942
D2690-17	Cable	5 Ea (1 ea)	90-Start up Operation	5044440
D2857-1	Hinge Bracket	5 Ea (1 ea)	90-Start up Operation	5056866
D2857-2	Hinge Bracket	5 Ea (1 ea)	90-Start up Operation	5057092
D2858-1	Hinge Bracket	5 Ea (1 ea)	90-Start up Operation	5156173
D2858-2	Hinge Bracket	5 Ea (1 ea)	90-Start up Operation	

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐			
NCR No. _____					
Date : _____		Step # _____		MRB (QSI042) Approval	
Description Work Order _____				Completed By _____	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 613 532-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE

Container No: S126537
Part: D350-588-011
Job No: 185553
Serial No/Batch: S126537

Revision: _____
Inspector: _____
Exp Date: _____
Instructions: TC STC SH92-41 Issue 8a, FAAS-01012N

Root Cause		DEFECT CATEGORY	
Environment	No Re-verification	Temperature/Cure	Power Loss/Surge
Design	Operator	Set-up	Folio/Program
Doc/Data	Offset/Setup	BOM/Route	Grain
Equip/Tooling	Supplier	Broken/Damage/Defect	Weld
Handling/Pre	Training	Inspection Incomplete/Unqualified	Wrong Stock Pulled
Material	Use for Testing	Contamination	Out of Sequence
Internal Transport	Poor Information	Countersink	Off-set
Tribal Knowledge	Rushing	Cut Too Short	Mislabeled
LOA	Product Improvement	Instructions Incomplete/Unclear	Fit/Function
Substation	Process Improvement	Drill Holes	Misaligned/off center
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		
OTHER :			

PK

D5080-041	Striker Plate Assembly	10 Ea (2 ea)
FG-778150-550-ROL	7781 9 oz Glass 50" x 125 yd	5 sf (1 ea)
MS20426AD3-4	Rivet	60 Ea (12 ea)
MS20470AD4-5	Rivet, Universal Head	90 Ea (18 ea)
MS21042L08	Nut	90 Ea (18 ea)
MS21042L3	Nut	20 Ea (4 ea)
MS27039-08-11	Screw	10 Ea (2 ea)
MS27039-1-15	Screw	10 Ea (2 ea)
NAS1149D0363J	Washer	20 Ea (4 ea)
NAS1149DN832J	Washer	120 Ea (24 ea)

90-Start up Operation
90-Start up Operation
90-Start up Operation
90-Start up Operation
90-Start up Operation
90-Start up Operation
90-Start up Operation
90-Start up Operation
90-Start up Operation
90-Start up Operation

5062594
5113976
FM134550
FM134294
5049829
5100409
5094592
FM138336-10
5112435
5095293
5034411

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN526C1032R7	10	123	0
	AN526C832R8	40	234	0
	AN526C832R9	40	123	0
	D2143	5	20	0
	D2144	5	19	0
	D2150	10	45	0
	D2151	10	30	0
	D2153	5	2	0
	D2154	5	25	0
	D2237	10	16	0
	D2461	36	484	0
	D2463	36	478	0
	D2583	10	8	0
	D2585	10	23	0
	D2586	10	33	0
	D2587	5	11	0
	D2589	5	213	0
	D2690-17	5	10	0
	D2857-1	5	11	0
	D2857-2	5	7	0
	D2858-1	5	6	0
	D2858-2	5	14	0
	D5080-041	10	10	0
	FG-778150-550-ROL	5	49	0
	MS20426AD3-4	60	4,602	0
	MS20470AD4-5	90	1,140	0
	MS21042L08	90	2,021	0
	MS21042L3	20	2,363	0
	MS27039-08-11	10	1,269	0
	MS27039-1-15	10	369	0
	NAS1149D0363J	20	1,591	0
	NAS1149DN832J	120	942	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																	
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																	
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																	
Large Fab ☐	Composite ☐	Supplier ☐																																																																		
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																
Description Work Order Deviation		Disposition		Completed By																																																																
				Lead hand / Supervisor Approval Verification																																																																
				QC / QA Coordinator Approval																																																																
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td><td style="border: none;">Temperature/Cure ☐</td><td style="border: none;">Power Loss/Surge ☐</td><td style="border: none;">Positioned Wrong ☐</td></tr> <tr><td style="border: none;">Bending ☐</td><td style="border: none;">Set-up ☐</td><td style="border: none;">Folio/Program ☐</td><td style="border: none;">Outside Dimensions ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td><td style="border: none;">BOM/Route ☐</td><td style="border: none;">Grain ☐</td><td style="border: none;">Over/Under tolerance ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td><td style="border: none;">Broken/Damage/Defect ☐</td><td style="border: none;">Weld ☐</td><td style="border: none;">Part Incorrect ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td><td style="border: none;">Inspection Incomplete/Unqualified ☐</td><td style="border: none;">Wrong Stock Pulled ☐</td><td style="border: none;">Part Lost/Missing ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td><td style="border: none;">Contamination ☐</td><td style="border: none;">Out of Sequence ☐</td><td style="border: none;">Part Moved ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td><td style="border: none;">Countersink ☐</td><td style="border: none;">Off-set ☐</td><td style="border: none;">Drawing ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td><td style="border: none;">Cut Too Short ☐</td><td style="border: none;">Mislabeled ☐</td><td style="border: none;">Finish ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td><td style="border: none;">Instructions Incomplete/Unclear ☐</td><td style="border: none;">Fit/Function ☐</td><td style="border: none;">Misread ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td><td style="border: none;">Drill Holes ☐</td><td style="border: none;">Misaligned/off center ☐</td><td style="border: none;">Turning Sequence ☐</td></tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																			
Design ☐	Operator ☐																																																																			
Doc/Data ☐	Offset/Setup ☐																																																																			
Equip/Tooling ☐	Supplier ☐																																																																			
Handling/Pre ☐	Training ☐																																																																			
Material ☐	Use for Testing ☐																																																																			
Internal Transport ☐	Poor Information ☐																																																																			
Tribal Knowledge ☐	Rushing ☐																																																																			
LOA ☐	Product Improvement ☐																																																																			
Substation ☐	Process Improvement ☐																																																																			
Past Expiry Date ☐	Manufacturing Process ☐																																																																			
Misidentified ☐	Past Due ☐																																																																			
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																	
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																	
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																	
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																	
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																	
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																	
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																	
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																	
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																	
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																	
OTHER : _____																																																																				

3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

• COPYRIGHT © 1992 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

REFERENCE ONLY

Revision: D

Date: 02.01.17

REFERENCE ONLY

REFERENCE ONLY

REFERENCE ONLY

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

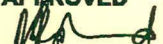
5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

REFERENCE ONLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH82-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REPTILES ONLY

REPTILES ONLY